

SLP 31/08

Date: Thursday, 8/30/2007 9:09:18 AM
User: Kim Johnston

Process Sheet

Split w/o
SO 07/08/30

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 34326
 Estimate Number : 11870
 P.O. Number : *NA*
 This Issue : 8/30/2007 S.O. No. : *NA*
 Prsht Rev. : NC
 First Issue : *NA* Type : MACHINED PARTS
 Previous Run : 33240

Drawing Name : HOUSING
 Part Number : D22071
 Drawing Number : D2207 UNDER REVIEW
 Project Number : N/A
 Drawing Revision : C
 Material : *NA*
 Due Date : 9/6/2007

Per D2207 Rev C
 PRELIM
 12 07/08/30

Written By : *[Signature]*
 Checked & Approved By : *[Signature]* 07.08.30
 Comment : Est. A 01.03.08 New Issue

Qty: 10 Um: Each

Additional Product

Part Number



Seq. # Machine Or Operation:

Description :

1.0 M6061T6S063 6061-T6 .063 Sheet



Comment: Qty: 0.4375 sf(s)/Unit Total: 4.3754 sf(s)

6061-T6 .063 Sheet

5052-H32 or 6061-T6 - .063" Thick

Batch *MIC5215**SAD 07/08/30*

2.0 SHEAR SHEAR



Comment: SHEAR

Shear blanks: 4.200" x 14.00" +.000"/-.030"

Grain along 14.00"

*Dwg rev C**Prog rev C**SAD 07/08/30 10*

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio FA031

Deburr

*Dwg rev C**Prog rev C**SAD 07/08/30**(10)*

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SAD 07/08/30**(10)*

5.0 QCB SECOND CHECK



Comment: SECOND CHECK

*Er 07/08/30**(10)*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07/08/30	C	Split w/o	SS	07/08/30	1			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: D Date: 07/08/31
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HOUSING

Job Number: 34326

Part Number: D22071

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend as per dwg D2207

SB 07/08/30 ①

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/08/30 ①

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

A 07/08/31 ①

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D 07/08/31 ①

Completion



U 07-08/31

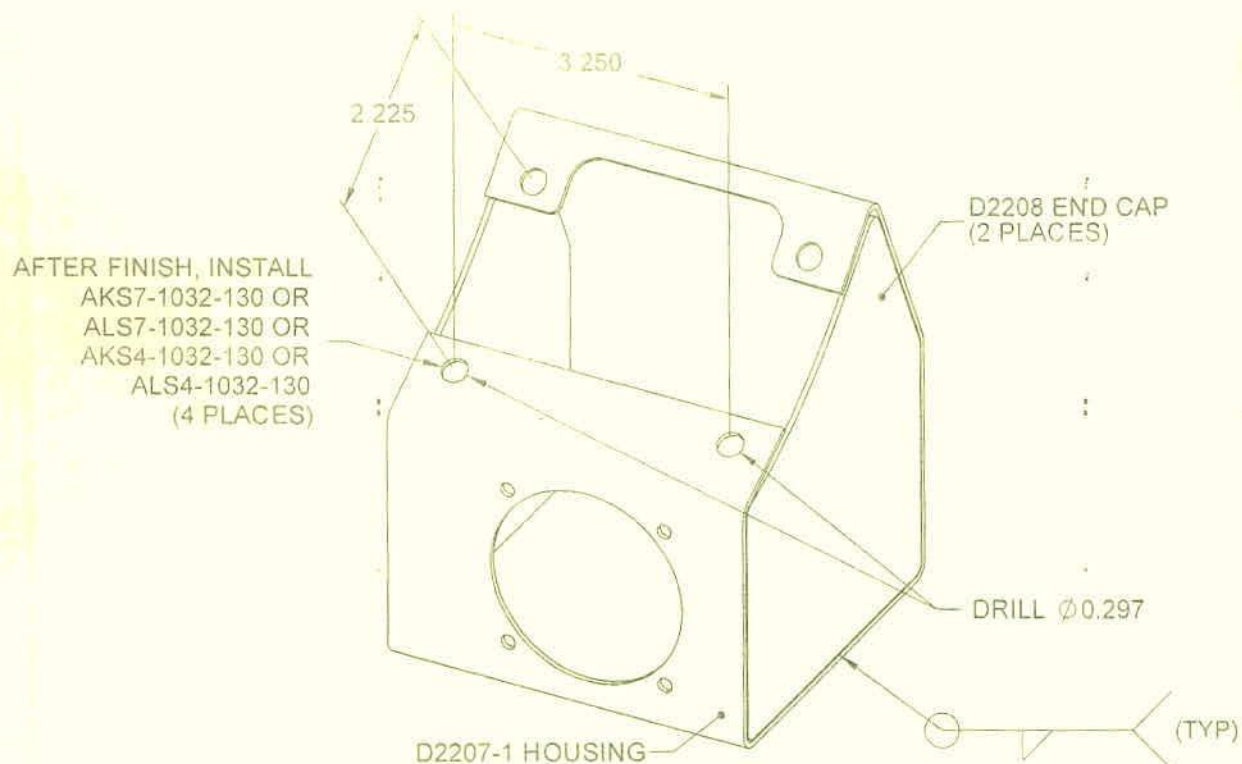
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2207-041 HOUSING ASSEMBLY

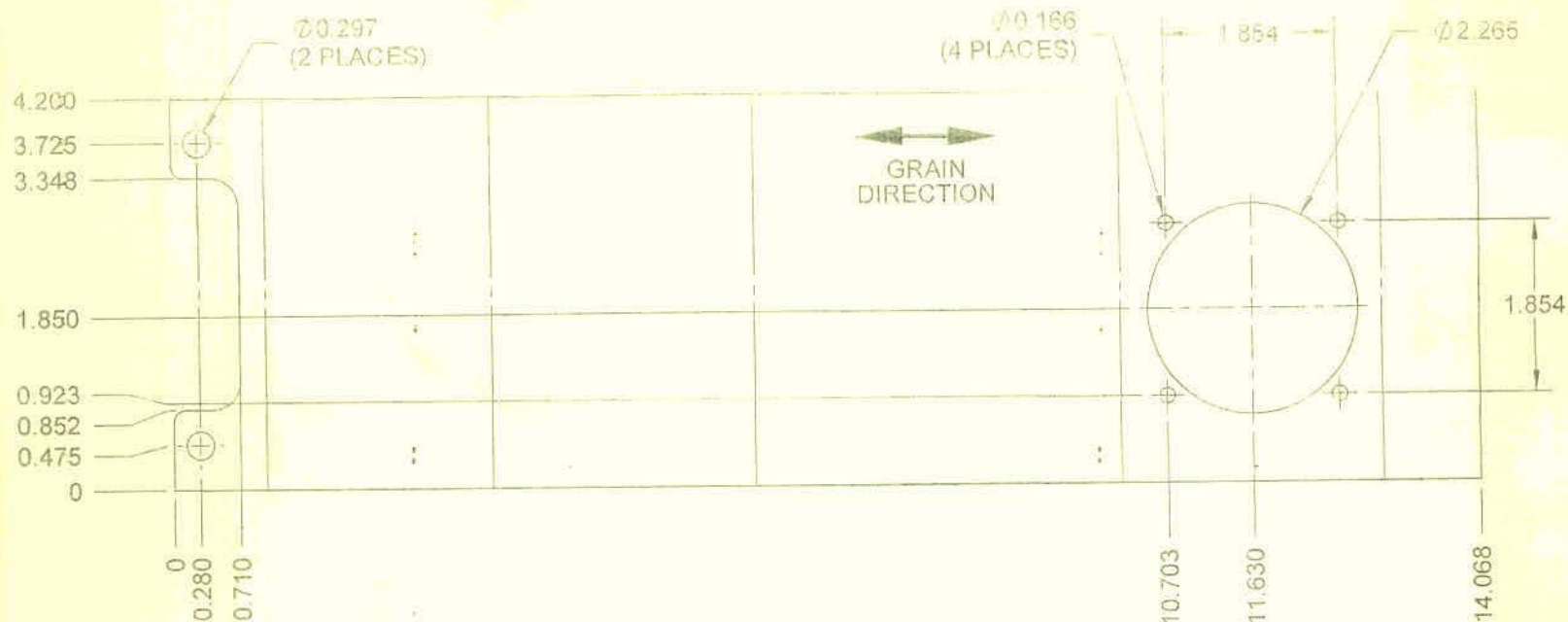
PRELIMINARY ISSUE

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34326

NOTES:

- 1) WELD PER DART QSI 004
- 2) GRIND WELDS FLUSH
- 3) FINISH: ACID ETCH AND ALODINE PER QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

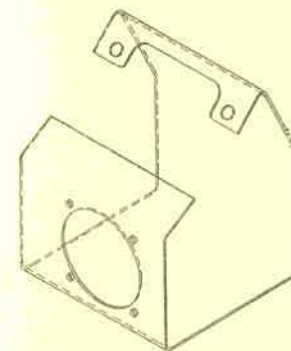
C	- UPDATE FLAT PATTERN - TOOLING REWORK REQUIRED	MB	07.06.28
B	REDRAWN	RF	01.02.23
A	NEW ISSUE	RF	94.09.01
REV	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	<i>EE</i>	D2207	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		HOUSING	1:2
DATE	07.06.28	COPYRIGHT © 1994 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION FROM DART AEROSPACE LTD.</small>	



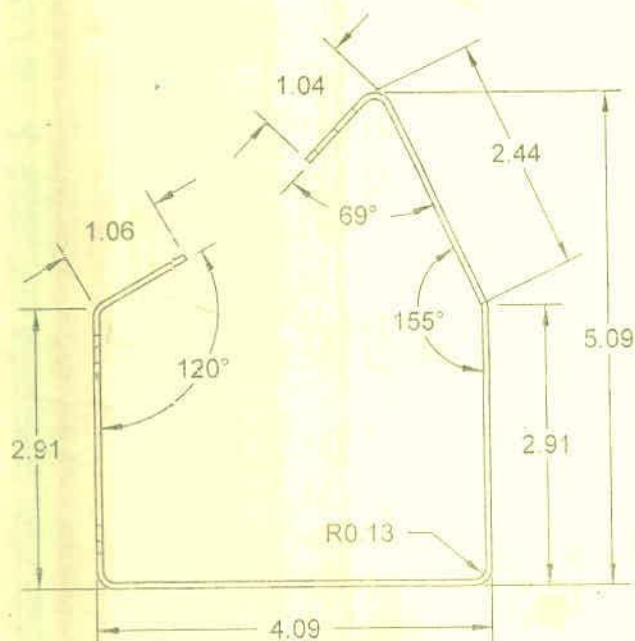
D2207-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: 5052-32 ALUMINUM SHEET (0.063 THICK)
PER AMS-QQ-A-250/8 OR AMS 4016
(REF. DART SPEC. M5052H32S.063) OR
6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.063 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



ISOMETRIC VIEW
(SCALE 1 : 4)



D2207-1 BENDING DETAIL

PRELIMINARY ISSUE

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WORK ORDER
NO. 347246

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CHECKED	PH	DRAWING NO	REV. C
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